

AI 345 058W

Work Order ID 74876

74876

Page 1

October 13, 2011 10:41:11 AM

Item ID: D3903-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacer
 Start Date: 10/13/11 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 10/27/11 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3903	B								

100 0.00

100

Hardinge

Hardinge CNC Lathe Small

Memo

1-TURN AS PER FOLIO FA813 & DWG D3903,
 FOLIO REV: AA
 DWG REV: A

2-DEBURR AS REQUIRED

40 0 and 11/10/24

110 0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

40 0 and 11/10/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: ST LG	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

11-10-25
40

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

October 13, 2011 10:41:16 AM

Page 1

Work Order ID: 74876

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Parent Item: D3903-1

D3903-1

Parent Item Name: Spacer

Start Date: 10/13/11

Required Date: 10/27/11

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	108.5780	0.345	14.52632			
M6061T6T0 375W 058									**	14.332' OK / 11/10/24			
6061-T6 RD Tube .375 x.058W													

Location

Loc Qty

Loc Code

MAT014

108.578

116920

0.578

118956

72

119087

36

14.332'

Dart Aerospace Ltd

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

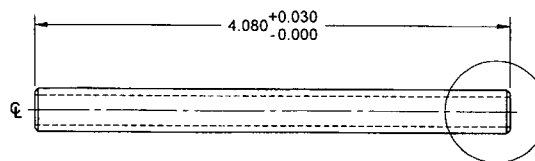
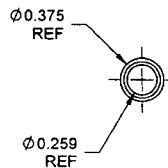
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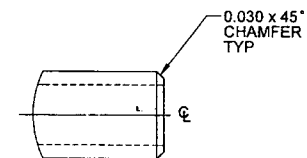
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74876

M.C.J

11/10/14



B2-1
DETAIL A



DETAIL A C3-1
SCALE 2X

D3903-1 SPACER

RELEASED
8/27/15

- NOTES:**
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM SEAMLESS TUBING 0.375" OD x 0.058" WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 OR ASTM B210 OR ASTM B241 (REF DART SPEC. M6061T0.313W.058)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.02 lbs

B	CORRECT TYPO Ø0.375 WAS Ø0.313 (ZN A6-1)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3903	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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